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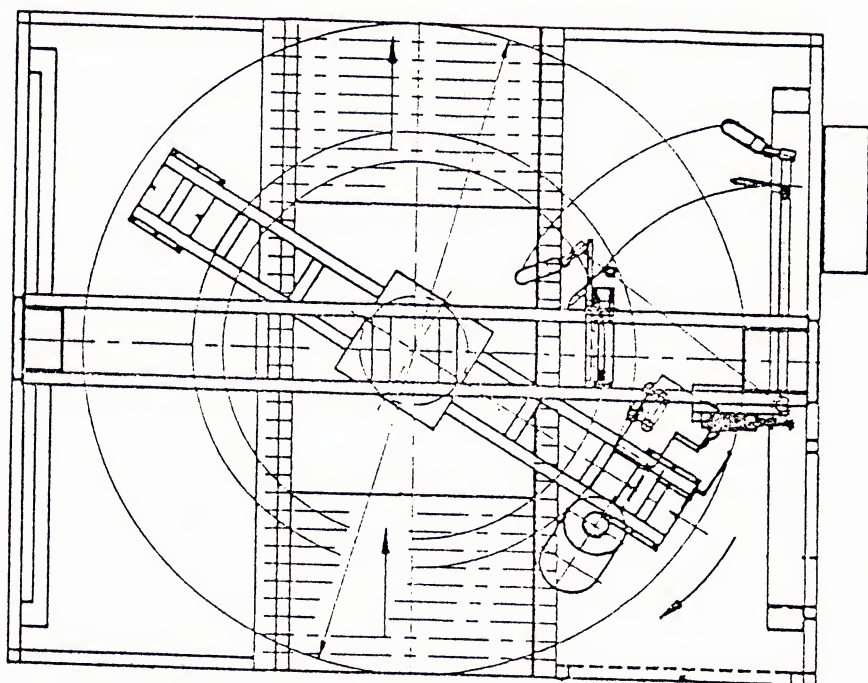
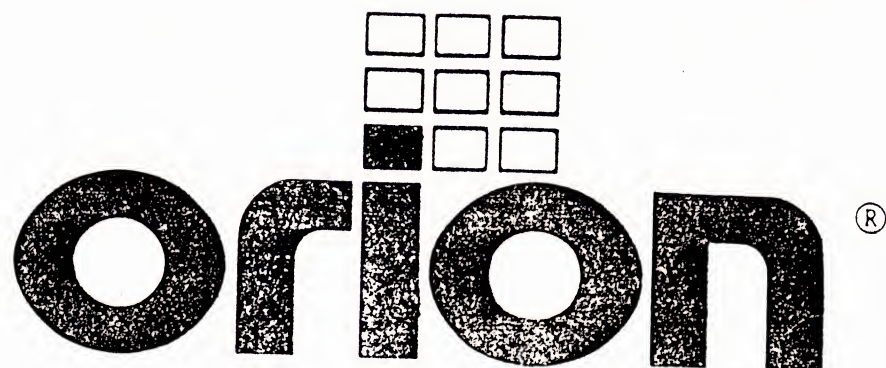
*TRI-STATE PAPER INC.
PROUDLY PRESENTS ORION STRETCH EQUIPMENT*

M-66/7 MONGOOSE STRETCH WRAPPER

OWNERS MANUAL SERIAL# 023367

REPAIR # 885-3365 





STRETCHWRAPPERS

2270 Industriel, Montreal (Laval) Canada H7S 1P9 / Tél.: (514) 667-9769 Fax: (514) 667-6320



INSTRUCTION MANUAL

2270 Industriel, Montreal (Laval) Canada H7S 1P9 / Tél.: (514) 667-9769 Fax: (514) 667-6320

Thank you for choosing ORION stretch-wrapping equipment. It is a wise choice which will benefit your company now and in the future.

ORION uses a unique combination of functional, rugged steel structure and sophisticated control systems to offer equipment high in durability and low in maintenance requirements. Our advanced control systems mean that ORION equipment can be operated safely and efficiently without the need for special operator expertise.

Please read this manual carefully and keep it handy. Following these simple operating instructions will insure the safe and efficient performance of this machine while simple maintenance procedures will guarantee a long and productive life of the equipment.

NOTICE:

Our manual covers standard features of the machine. Certain options may not be fully covered due to their unique application.

In order to acquire more information about custom made features of your machine and to provide quicker service, the following information is required when making an inquiry:

- 1) MODEL
- 2) SERIAL NUMBER 023237
- 3) SUBASSEMBLY (see PART LIST)

SAFETY:

ORION'S stretch wrappers should be operated with caution and common sense as any other industrial equipment. To prevent injury and / or electrical shock, careful operation of the machine and awareness of its many automatic functions is required.

Note: All electrical power and compressed air must be disconnected prior to performing any inspection, maintenance or repair work.

ORION PACKAGING INC.

ORION MODEL M-66**Spiral Semi-Automatic Heavy Duty Wall Mount Rotary Tower**

Maximum Load Size:	52"W x 52"L x 80"H (Recommended) 56"W x 56"L x 84"H (Theoretical)*
Weight Capacity:	Unlimited (Floor Loaded)
Utilities:	115/1/60 20 Amp Service
Rotary Tower:	All Structural Steel Easy Access to All Components Steel Tube Matrix Design
Tower Drive:	20" Diameter Ring Bearing Tower Support Chain/Sprocket Gear Drive 0 - 12 RPM Variable Tower Speed 1/2 HP DC/SCR Drive Electronic Soft Start Positive Tower Alignment Feature
Control Features:	Reliable Relay Logic Control System Safety Stop Photoell Electronic Film Force Control End of Cycle Film Force Release Separate Top and Bottom Wrap Selectors Variable Speed Film Carriage Control Auto-Height Photoell with On/Off Switch Film Carriage Raise/Lower Switch Tower Jog Pushbutton Spiral Up or Up/Down Cycles NEMA 12 Electrical Enclosure
Film Delivery:	20" Orion MultiStretch Power Prestrech Electronic Film Tension Control End of Cycle Film Force Release Full Authority Film Dancer Bar #40 Chain & Sprocket Stretch Ratio Control 1/3 HP DC/SCR Film Drive Low Wrap Feature (Minimum 3")
Film Carriage Drive:	#50 Roller Chain Carriage Lift 1/3 HP Elevator Drive Motor Variable Speed CR Control Precision Cam Follower Tracking
Structural Features:	Wall or Beam Mounting Design All Structural Steel Construction 6" x 12 lb./ft. "H" Beam Mast
Estimated Shipping Weight:	1,250 lbs.

*THEORETICAL MAY INCREASE OPERATOR DIFFICULTY IN PROPER LOAD PLACEMENT, AND REFLECTS MAXIMUM FILM WEB HEIGHT ATTAINABLE.

MACHINE UNLOADING INSPECTION & INSTALLATION

UNLOADING

Machine can be easily unloaded and transported by a forklift with a minimum capacity of 2500 lbs.

1. Carefully insert the forks into the lifting tubes to the maximum possible depth. Depending on the model, a forklift access may be either at the turntable end of the machine frame, the tower end or both. In case of the mongoose machine or the conveyor, enter the forks under the frame.

2. Lift the machine (or other part of system) only to the necessary height to move it with no bouncing or friction on the floor.

2a. On the mongoose machines use the brackets welded on the top part of the machine.

3. Sit the machine down assuring uniform contact with the floor which is necessary to ensure correct and smooth operation.

3a. Mongoose type machines (M66, M67) have to be attached on the bracket or on the stand (collapsible or anchored to the floor). The M55 has it's own supporting frame which allows the machine to stand independently.

INSPECTION

1. Remove all packing and supporting additions - these may include the blocks under the carriage and the restraining bar over the table.

NOTE: when removing the stretchwrap film covering the machine, care must be taken not to cut any of the electrical wires and rubber covering on the multistretch rollers.

2. Perform a visual inspection of the electrical and mechanical parts for loosened joints and / or broken connections. Any suspected shipping damage must be reported immediately to the freight carrier.

Items that are vulnerable to damage and must be inspected are as follows:

- motors and transmissions
- junction boxes
- electrical conduits
- proximity and limit switches
- photocells

3. Check under the turntable (H - series models only) to ensure that there is no crippling of the movable parts i.e. casters, center axle or drive assembly.

4. Verify the following:

- turntable or rotary arm drive system to confirm that the reducer to drive the chain is snug and properly aligned
- verify the wires tight conduits for crushed sections or loose fittings
- verify the carriage to be sure that it is correctly aligned with the tower and verify the tension on the lift chain
- verify all the dials and knobs on the control panel for smooth action.

MACHINE INSTALLATION

After the visual inspection has been completed the electrical power and the compressed air may be connected as specified on the diagrams supplied with the machine.

An electrical diagram is provided with each machine in the envelope attached to the panel box.

ASSEMBLY PROCEDURE

The structural frames of the machine have to be installed on a levelled floor. Locate the main wrapper section into its final position, keeping the tower assembly* away from any traffic.

The wrapper mainframe section must be bolted to the floor by the 1/2" concrete floor anchors (leg & shield or expandable type).

Conveyor sections (where applicable) have to be positioned, levelled** and bolted to the floor. Any wiring which has been disconnected to facilitate transport is marked with a number located on the junction box to which the wiring must be reconnected. It allows identification of the proper position of the infeed and outfeed conveyor sections. Any wire run that appears too short or long may indicate that the position of the mechanical components is incorrect. Verify the status of all assemblies before proceeding.

CAUTION: improper placement and alignment of the conveyor section(s) and/or electric photocells may lead to equipment malfunction and damage.

* The tower deviation from vertical must not exceed 1/4" on the distance of 10 feet (angle: 0 degrees 6').

** In the case of the conveyors, the roller deviation from the horizontal must not exceed 1/16 "on the distance 52" (angle: 0 degrees 4').

CYCLE CONTROLS

The control panel layout is custom designed for each particular installation, however, common standard controls have been employed.

CAUTION: before proceeding be familiar with the EMERGENCY button and all functions, switches and pushbuttons.

POWER SWITCH

The Power Switch has two settings:

ON - connects a power source to the machine (voltage depends on the machine type - see electrical diagram provided with the machine).

OFF - disconnects the power source.

START AND STOP SWITCHES (EMERGENCY STOP)

The START switch is used to start the cycle once the load is on the turntable (or under the rotary arm). The cycle may be stopped at anytime by pressing the STOP button.

NOTICE: In case of emergency, use the STOP button which interrupts all the machine electrical circuits (except multistretch drive). If the STOP pushbutton is pressed in the middle of the cycle, the carriage and turntable may be returned to their home position by using the jog buttons before restarting the cycle.

SPIRAL WRAP SWITCH

The SPIRAL WRAP switch has two positions:

UP - in this position the cycle will end after completing the specified number of top wraps, therefore, the machine will only wrap the load once, going up.

UP/DOWN - in this position the cycle will be completed after the load is wrapped in both the up and down directions.

NOTE: TOP WRAP FIRST (OPTIONAL)

The carriage raises faster at the beginning of the cycle to wrap the top of the load (see electrical diagram provided with the machine).

CARRIAGE CONTROL SWITCH

The CARRIAGE CONTROL switch is a three position switch with the following settings:

RAISE - raises the carriage until the top limit switch on the tower is activated.

LOWER - lowers the carriage until the bottom limit switch on the tower is attained.

The switch is normally positioned in the middle where the carriage remains stationary. Turning the switch to the RAISE or LOWER will activate the carriage to move in its respective direction.

TURNTABLE (ROTARY TOWER) JOG

The turntable (rotary tower) jog switch is a pushbutton which will rotate the turntable (rotary arm) in a clockwise direction (as viewed from the top) when the switch is held depressed. When the switch is released the turntable (rotary tower) will stop. The switch is inoperative during the wrap cycle.

PHOTOCELL SWITCH

The photocell switch has two settings:

ON - when turned ON, the photocell instructs the carriage to stop and begin the top wraps sequence once the top of the load is reached. The carriage will always stop at the top of the load regardless of its height. The photoswitch position on the track can be adjusted in order to make the carriage pass the top of the load and overlap the top.

OFF - when turned OFF, the photocell is inoperative and the carriage will stop when the top limit switch has been activated.

FILM TENSION

Film tension may be adjusted using the film tension control knob. It has a range of tension from 0 to 10 (0 to 4 the low range, 4 to 8 the most usefull range for most of the films used by our customers, 8 to 10 as a very high range which may break some films).

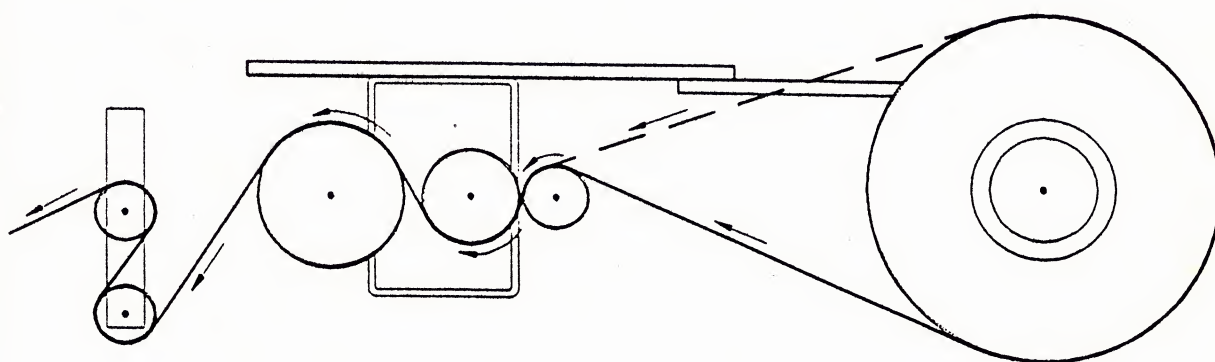
NOTE: Lighter loads may require lower tension settings then heavier loads.

Film tension is controlled through the dancer bar system. Occasionally the feed back proximity sensor may need some adjustment. Adjustment of feed back is shown on drawing # 001

Adjustment instructions:

- remove the carriage cover
- unbolt the two nuts holding the proximity switch -item # 1
- turn the proximity switch - item # 2 until the moment when the motor starts to turn (or hums)
- tighten on the nuts securing the proximity switch.

NOTE: The condition in which the motor hums but does not turn must be maintained even after all elements are tightened. If not, the adjustment procedure must be repeated.



WARNING:

DISCONNECT POWER BEFORE FEEDING FILM

**FILM FEEDING PATTERN
FOR "M" SERIES CARRIAGE**

TO LOAD THE FILM....

The film roll can be loaded on the mandrel of the carriage from either end of the roll. When using tacky film, please verify that the inward tacky surface of the film is inward on the load.

1. Disconnect power (turn off power switch).
2. Put the roll of film on the mandrel and press down to insure penetration of spikes into the card board center of the film roll.
3. In the case of automatic machines, install the film cap on top of the roll to prevent upward movement.
4. Introduce the roping end of the film between the shafts of all rollers (as shown on the dwg.) and pull to pass it around all three rollers (pressure roller and both rubber rollers).
5. Pass the film between the two dancer (aluminium) rollers (in certain applications the film has to be passed around one or two additional position aluminium rollers).
6. When the film feeding is completed - turn the power switch ON
7. Peel off the first few winds of the film (multistretch will run due to displacement of the dancer roller) and fix the film end onto the load or into the clamp mechanism (if machine is fully automatic).

The system is now ready to begin the first wrapping cycle.
Proceed to page titled SYSTEM START UP.

SYSTEM START-UP

Notice: It is advisable to test-run the equipment with several pallet loads before make the attempt to wrap with film. Please position a worker at the EMERGENCY STOP push button.

Start up of the machine (system) may determine the need for the adjustment of:

- pallet sensor eyes (automatic systems only)
- load height stop photoswitch (on the carriage)
- conveyor acceleration/deceleration
- turntable speed & jog speed
- turntable speed acceleration/deceleration
- turntable home position (rotary tower home position)
- film tail treatment devices (automatic systems).

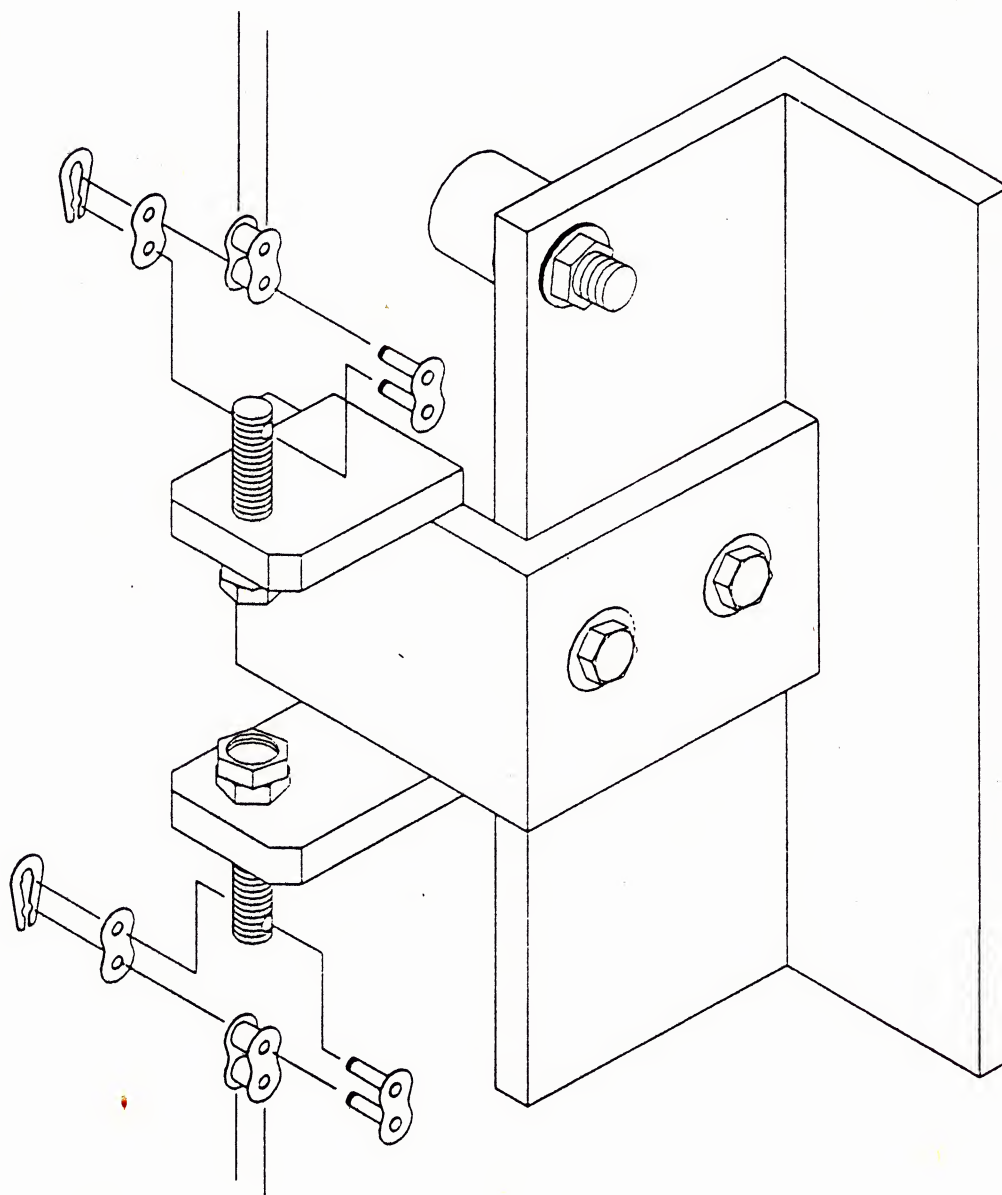
MACHINE WRAPPING TEST

Before the test procedure adjust the wrapping cycle parameters i.e. top wraps, bottom wraps, height photocell on/off, film tension, carriage speed (those two parameters may be adjusted during the wrapping cycle).

When there is no photocell, verify the top limit switch position.

ATTENTION:

**WHEN MOUNTING THE CARRIAGE LIFT CHAIN,
PLEASE ENSURE, THAT THE CONNECTING
LINK'S PIN IS INSERTED FROM THE TOWER SIDE**



CHAIN TENSIONER ASSEMBLY

MACHINE MAINTENANCE

On the reducing transmission, after the first week all external cap screws and plugs should be checked for tightness. It is recommended to change the oil every six months or 25000 hours of operation, which ever comes first. When adding oil, the transmission should never be filled above the oil level mark indicated, because leakage and overheating may occur. Below is a list of the type of lubricant that should be used:

Manufacturer	Lubricant
American Oil CO.	American Cyl Oil no:196-L
Cities Service Oil Co.	Citgo Cyl.Oil 100-5
Gulf Oil Corp.	Gulf Senate 155
Mobil Oil Corp.	Mobil 600 W Suerr Cyl.Oil
Philips Oil Co.	Andes S 180
Texaco Inc.	624+850T Cyl.Oil
Shell Oil Co.	Velvata Oil J82
Union Oil Of Cal.	Red Line Worm Gear Lube 140

MOTOR MAINTENANCE

An occasional inspection of the brushes should be made in order to establish a wear rate. Replacement brushes should be installed before old brushes wear to 9/16" long, measured on the long side. After replacing brushes run the motor near rated speed for at least 1/2 hour with no load to seat the new brushes.

Failure to properly seat the new brushes may cause commutator damage and rapid wear of the new brushes. If the commutator becomes rough, scored or out of shape, a competent motor shop should disassemble the motor and resurface the commutator. With every third brush change, have a competent motor shop resurface the commutator and blow the carbon dust out of the motor.

CHAIN MAINTENANCE

To clean the chain, wipe it with an oily cloth every month. If the environment is very dusty or damp, it may be necessary to clean it more often.

With time the chain will tend to stretch. A loose elevator and turntable (rotary arm) chain should be tightened at the chain tensioner, or by moving the reducer on the mounting plate.

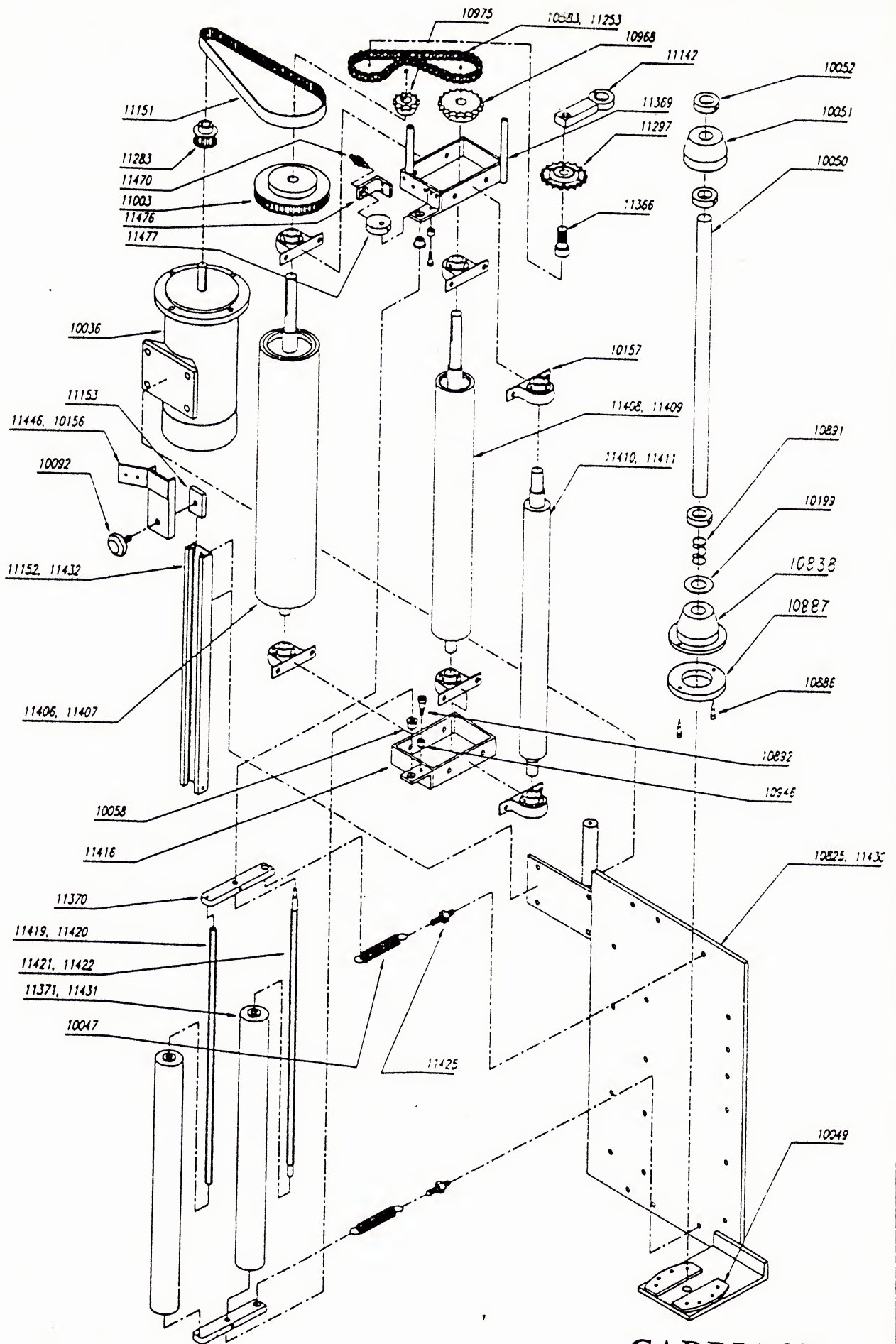
CAM FOLLOWER MAINTENANCE

The cam followers behind the carriage have deep grease pockets and do not need frequent relubrication. The portion of the tower on which the cam followers run, should be cleaned and regreased every 300 hours of operation. If the machine operates in a dusty or corrosive environment the tower should be relubricated more often.

SEMI-AUTOMATIC STANDARD ASSEMBLY PART LIST

Note :

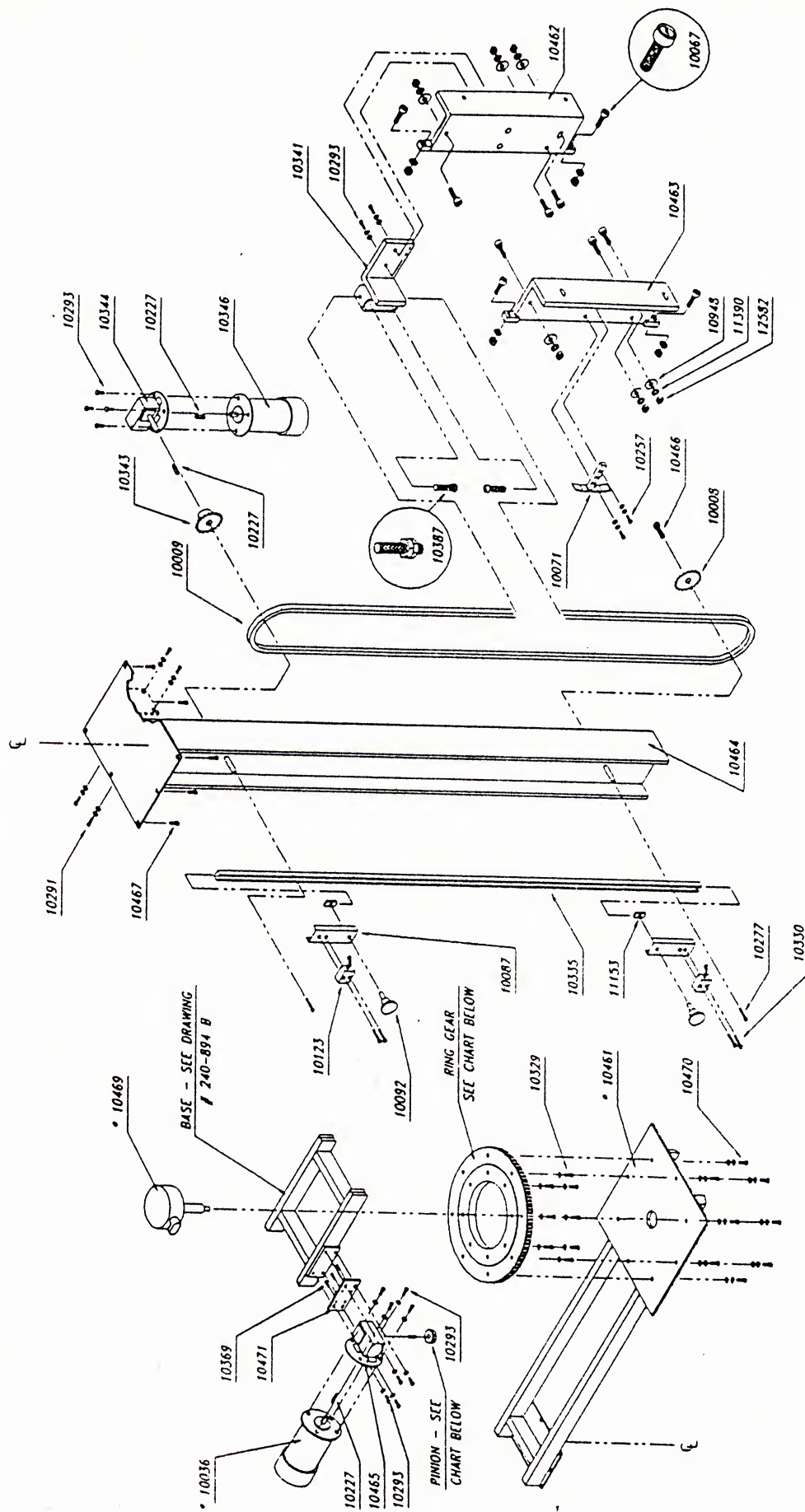
- * Quantity listed in order of part number**
- ** The names given to the parts are generic**



CARRIAGE

Carriage Parts List Series 6

10036	Motor, el. 1/2HP 90VDC 1750RPM	1
10047	Spring, tension	2
10049	Pads, brake 1/4" th.	Set of 2
10050	Spool mandrel (for 20" & 30")	1
10051	Mandrel, top	1
10052	Collar 1" I.D.	3
10058	Bushing bronze	2
12090	Bracket, photoswitch (LH)	1
10157	Bearing, pillow block 3/4"	6
10199	Washer	1
10583	Chain #40	1
10825	Back plate f/20" film	1
10838	Mandrel, bottom spool	1
10886	Spike, spool	2
10891	Spring, compression	1
10892	Screw, shoulder 5/16"dia. x 3/8"lg.	2
10946	Hose, plastic (for P/N 10892)	2
10968	Sprocket, drive	1
10975	Sprocket, drive	1
11003	Pulley	1
11142	Tensionner, chain	1
11151	Belt, timing	1
11152	Channel, photocell (20" film)	1
11153	Guide, channel	1
11253	Link, connecting #40	1
11283	Pulley, timing belt	1
11297	Sprocket	1
11366	Screw, hex head, 5/8"NFX1 1/2"lg.	2
11369	Bracket, top	1
11370	Lever	2
11371	Roller, dancer, 21 1/4" lg.	2
11406	Roller, rubber, 4"dia.x21" lg.	1
11407	Roller, rubber, 4"dia.x31" lg.	1
11408	Roller, rubber 2.66"dia.x21"lg.	1
11409	Roller, rubber, 2.66"dia.x31" lg.	1
11410	Roller, pressure 1 3/4" dia.x21"lg.	1
11411	Roller, pressure, 1 3/4" dia.x31"lg.	1
11416	Bracket, bottom	1
11419	Shaft, short, f/ P/N 11371	1
11420	Shaft, short, f/ P/N11431	1
11421	Shaft, long, f/ P/N11371	1
11422	Shaft, long, f/ P/N11431	1
11425	Rod, threaded, 2/8"UNCx2"lg.	2
11430	Back plate for 30" film	1
11431	Roller, dancer, 31"lg.	1
11432	Channel, photocell (for 30" film)	1
12091	Bracket, photocell, (RH)	1
11470	Sensor, proximity	1
11476	Bracket, proximity sensor	1
11477	Cam, proximity sensor	1
10887	Disk, mandrel brake	1



MACHINE TYPE	RING GEAR		PINION	
	SYMBOL	PART NO.	SYMBOL	PART NO.
M-57, M-67, M-77	VLA 160235	10984	10M4/11M4	11897/11886
M-55, MA-55, M-66, MPA-44	VLA 200-14	10460	12M5	10468
M-44, MA-44	VLA 200344 N	10910	12M6	10804

ROTARY TOWER ASS'Y

* ITEM MAY VARY DUE TO MACHINE MODIFICATIONS

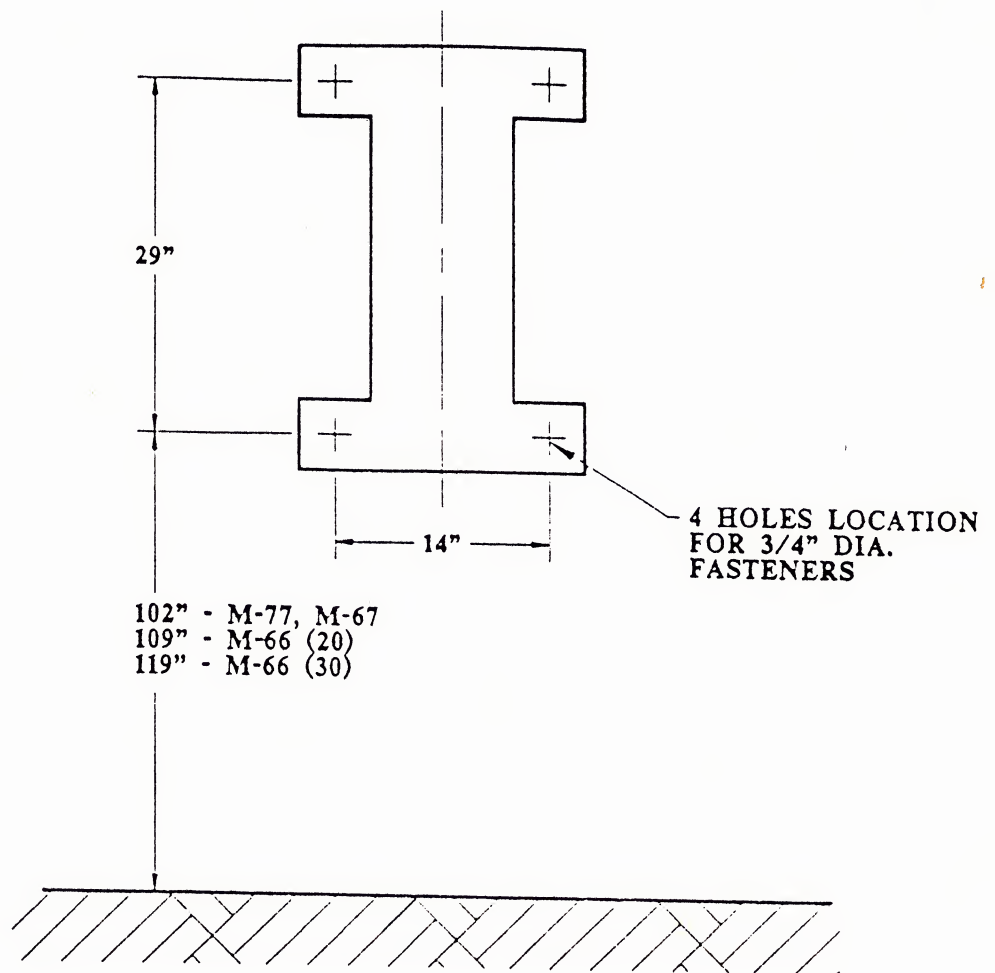
MONGOOSE ROTARY TOWER ASS'Y - PART LIST

ORION PART NO.	DESCRIPTION	Q-TY
10008	IDLER SPROCKET, 16 TEETH AG2416	1
10009	CHAIN # 50	1
10036	ELECTR. MOTOR, 1/2 HP, 90 VDC, 1750 RPM	1
10067	CAM FOLLOWER 3/4" CF12	10
10071	ACTUATOR, LIMIT SWITCH (STD)	1
10087	LIMIT SWITCH BRACKET	2
10092	KNOB, BLACK # 193	2
10123	LIMIT SWITCH XCK-2115	2
10227	SQUARE KEY, 3/16"	3
10257	1/4-20 x 1/2" LG. S.H.C.S.	2
10277	1/4-20 x 1" LG. S.H.C.S.	2
10291	5/16-18 UNC x 1" LG. BOLT	4
10293	3/8-16 x 1" LG. H.H. BOLT, GR.52C	10
10329	5/8-11 UNC x 1 1/2" LG. H.S.C.S.	8
10330	10-24 UNC x 2" LG. S.H.C.S.	2
10335	CHANNEL, DWG. # 220794 A	1
10341	CHAIN TENSIONER, DWG. # 200-126 A	1
10343	SPROCKET, 50B14 x 7/8" BORE	1
10344	REDUCER BQ 175 50:1 ASS'Y-3	1
10346	ELECTR. MOTOR, 1/3 HP, 90 VDC, 1750 RPM	1
10369	5/16-18 UNC x 1" LG. C.H.C.S.	4
10387	CHAIN TENSION SCREW 1/2-13 x 2 1/2" LG.	2
10460	EXTERNAL RING GEAR, 20" DIA. 99 T.	1

MONGOOSE ROTARY TOWER ASS'Y - PART LIST

CONT.

ORION PART NO.	DESCRIPTION	Q-TY
10461	MONGOOSE ARM - LENGTH VARIES WITH MODEL	1
10462	RIGHT CARRIAGE HOLDER	1
10463	LEFT CARRIAGE HOLDER	1
10464	TOWER, DWG. # 200-829 C	1
10465	REDUCER BQ 175 20:1, ASS'Y-3	1
10466	1/4-28 UNF x 1/2 LG. H.H. BOLT	1
10467	3/8-16 UNC x 1" LG. H.H. BOLT	8
10468	PINION, 12TM5 , 7/8" BORE	1
10469	SLIP RING ASS'Y, 15 WIRE, MAY VARY WITH MODEL	1
10470	M12 x 1.75 METRIC HEX BOLT 40 mm LG.	8
10471	REDUCER MOUNTING PLATE	1
10804	PINION, 12TM6, 7/8" BORE	1
10910	EXTERNAL RING REAR, 25" DIA. 105 T.	1
10948	FLAT WASHER, 3/8"	6
10984	EXTERNAL RING GEAR, 13" DIA. 78 T.	1
11153	CHANNEL GUIDE, DWG. # 220-518 A	2
11390	LOCK WASHER, 3/8" I.D.	10
11886	PINION, 11TM4, 7/8" BORE	1
11887	PINION, 10TM4, 7/7" BORE	1
12582	3/8-20 UNF HEX NUT	10



MODEL		ASSUMED FIXING MOMENT	ASSUMED FIXING FORCES
MONGOOSE	CARRIAGE		
M-67 M-77	20"	6 000 LBS/FT 72 000 LBS/IN 830 KG/M	2 483 LBS 1 130 KG
M-66	20"	7 500 LBS/FT 90 000 LBS/IN 1 040 KG/M	3 100 LBS 1 410 KG
M-66	30"	8 300 LBS/FT 99 600 LBS/IN 1 150 KG/M	3 435 LBS 1 560 KG

BOLTS PLACEMENT FOR MONGOOSE INSTALLATION

TURNTABLE & TOWER MOTOR CONTROL BOARD ADJUSTMENTS

66 & 55 SERIES EQUIPMENT (850M Board)

INTRODUCTION

The 850M Motor Control Board is a DC/SCR drive that is used in 66 & 55 series Orion stretch wrapping equipment. The following calibration instructions apply to all 66 & 55 series turntable and rotary tower type machinery, but it will be important to note specific reference to your particular Orion model for best calibration results.

The 850M board features two selectable pre-set speeds 1 & 2, and four potentiometers, marked 1, 2, A and D.

The instructions are in the suggested order of adjustment, and are intended to be made after installation of the board in the control enclosure. Please refer to the attached sketch of the board for identification of the adjustment points.

INSTALLATION

The unit is equipped with an aluminum chassis, which serves as a heatsink. This should be oriented with the printed circuit board in a vertical plane for optimum convection cooling.

Connections are to .250" quick-disconnect terminals. Standard units require 120 VAC supply. AC line attaches to terminals AC1, AC2. Motor Armature attaches to terminals DC+, DC-. The standard unit is suitable for permanent magnet shunt style DC motors with 90 V armature rating, rated at up to 1HP.

APPENDIX

ELECTRICAL BOARDS' CHART FOR ORION STRETCHWRAPPERS

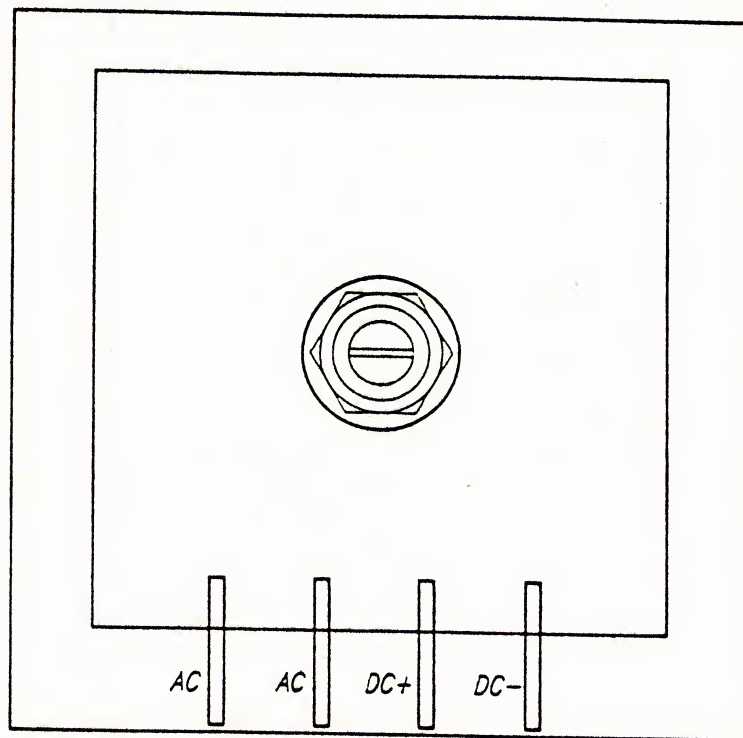
	168-4	168-A	336-6 & 7	750 MX	850 M	850 C	155-3	850 D
L-77, H-77		X					X	X
M-77		X				X	X	X
M-67		X	X			X	X	
M-67 PA		X	X		X		X	
M-67 DEMO		X	X		X		X	
M-66, L-66, H-66		X	X		X		X	X
M-57		X	X			X	X	
M-55, L-55, H-55		X	X		X		X	
M-44, L-44, H-44	X	X	X	X			X	
*M-44,*L-44,*H-44	X	X	X	X				

* - PROCESSOR

PA - POSITIVE ALIGNMENT

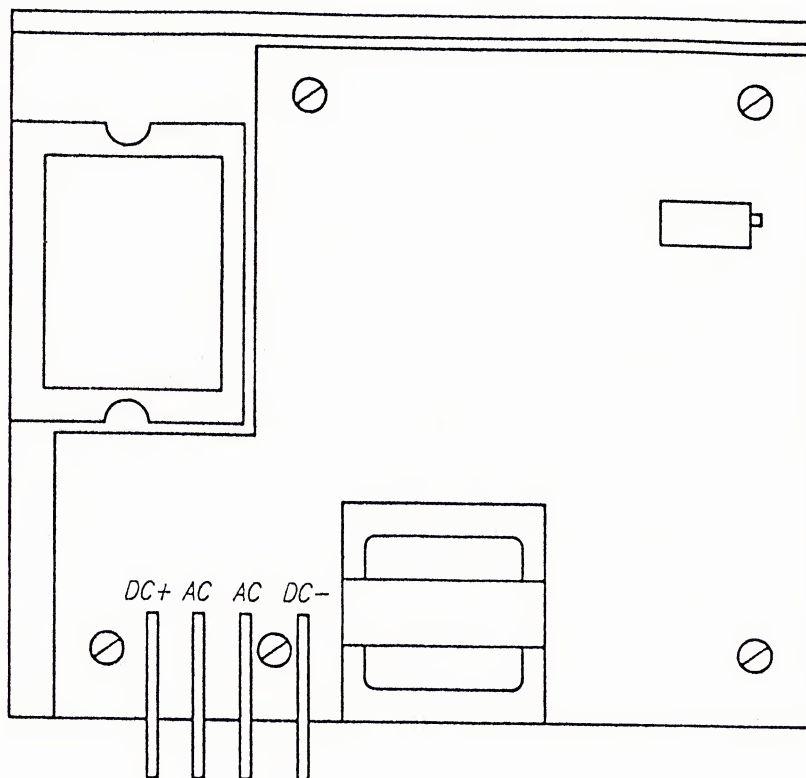
DEMO - DEMO PACKAGE

336-7 - REPLACES 336-6

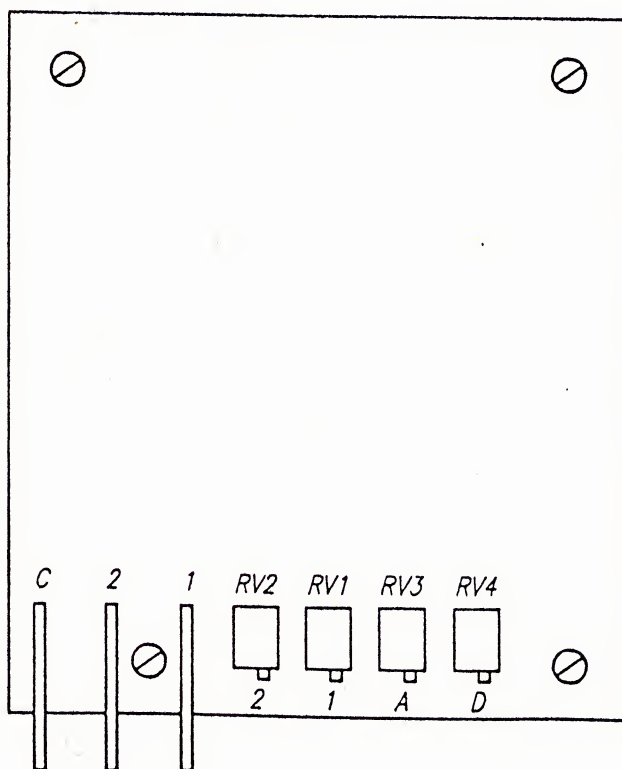


AC: AC INPUT
AC: AC INPUT
DC+: ARMATURE CONTROL
DC-: ARMATURE CONTROL

168-A
CARRIAGE SINGLE SPEED BOARD



DC+: ARMATURE CONTROL
 AC: AC INPUT
 AC: AC INPUT
 DC-: ARMATURE CONTROL



C: COMMON
 2: SPEED CONTROL (HIGH)
 1: SPEED CONTROL (SLOW)

POTENTIOMETERS:

2: HIGH SPEED ADJUSTMENT
 1: LOW SPEED ADJUSTMENT
 A: ACCELERATION ADJUSTMENT
 D: DECELERATION ADJUSTMENT

850M 2 SPEED DC
 MOTOR CONTROL BOARD

ADJUSTMENTS

Acceleration: (RV3) The pot marked A is the control for the acceleration or electronic soft start feature.

For an initial setting, turn the A pot fully counter clockwise (CCW) (until a faint clicking sound is heard), and then approximately 2 turns or revolutions clockwise (CW). CW adjustment of this potentiometer softens the start and lengthens the time required for the turntable/tower to reach it's preset speed. CCW quickens the start and decreases the time for the turntable/tower, to reach it's preset speed.

Speed Control: (RV1) The pot marked 1 controls the turntable/ tower jog speed¹.

Simply activate the turntable/tower jog function, adjusting the jog speed (pot 1) as the tower/turntable rotates. This should be set for approximately 2-3 R.P.M... Please note that this setting should be made with a load on the turntable (turntable type models only). A CW turn increases jog speed, while CCW decreases jog speed.

Speed Control: (RV2) The pot marked 2 is the control for the high speed² for the turntable/tower during the wrap cycle once acceleration is complete.

This speed can be as high as 12 R.P.M.; however you should note that if it is set to high, you may see chopping of the current to the turntable/tower drive motor which will cause pulsating half speed operation of the turntable/tower drive itself. If this is seen, please decrease the setting of pot 2, until it is no longer in effect.

For best calibration results, it is recommended that you make this adjustment while the machine is in cycle. After starting a wrap cycle set the film carriage speed control to the "0" (minimum) position. This will prevent the film carriage from rising and completing its cycle. Then simply adjust the high speed (pot 2) as the tower/turntable rotates. A CW turn increases speed, while a CCW turn decreases speed.

¹ Speed Control 1 = Turntable/Tower Jog Speed

Selected by a 120 VAC signal applied from terminal (1) to (C)

² Speed Control 2 = Turntable/Tower High Speed

Selected by a 120 VAC signal applied from terminal (2) to (C)

Deceleration: (RV4) The pot marked D is the deceleration control. Functionally, it is the opposite of acceleration, except that it is a more critical setting in that our machine logic requires that we decelerate from speed 2 to speed 1 during the course of the final revolution of the turntable/tower before shutoff.

For an initial setting, start with the D pot set fully CCW. Then, cycling the machine, observe the transition to jog speed at the end of the cycle, prior to the stop of the turntable/tower at home position. Gradually increase the D pot setting (CW) until the turntable/tower only jogs approximately 1/8 to 1/4 revolution before reaching home position. CW adjustment of this potentiometer quickens the stop and shortens the deceleration time required for the turntable/tower to settle to its preset jog speed. While CCW softens the stop and lengthens the time required for the turntable/tower to settle to its preset jog speed.

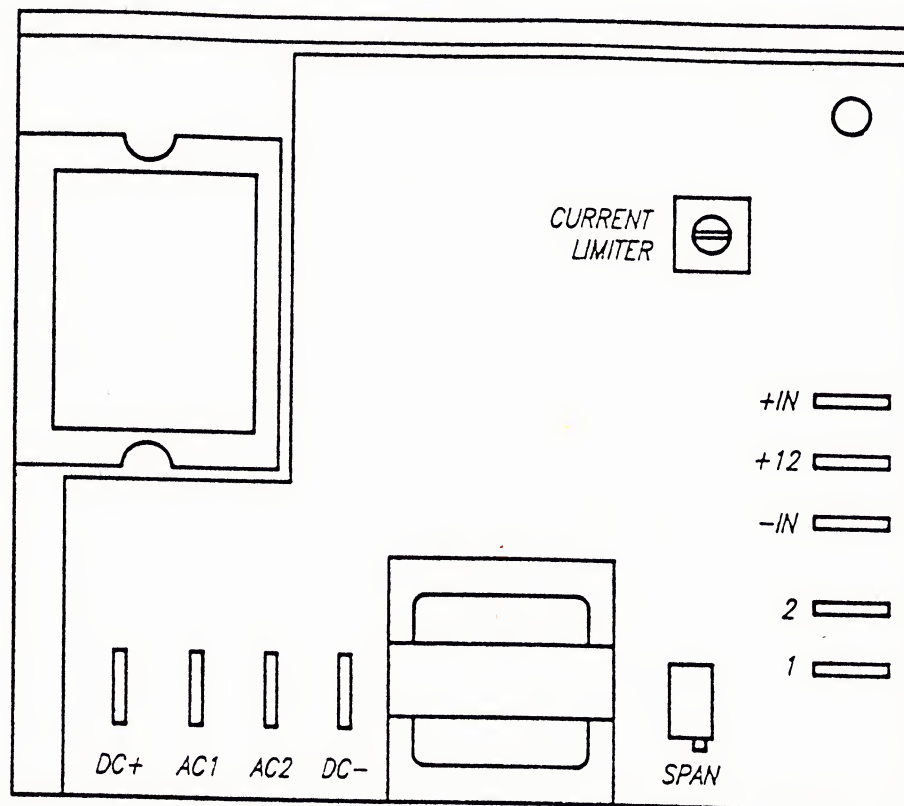
Thus the deceleration control is important in that if the deceleration time is too short, we will prematurely reach jog speed and jog an excessive amount of time to the home position before shutoff.

Conversely if the deceleration time is set too long, the turntable/tower will not settle to the jog speed and thus will be going too fast to align properly and momentum will take the turntable/tower beyond home position. As you can imagine, any time the wrap speed is changed, you will need to make a corresponding change in the setting of the pot marked D for deceleration.

TROUBLE SHOOTING & REPAIR

In most cases repair will require parts replacement. If user intends to, and is equipped to perform repairs, spare parts are available from Orion Parts & Service.

Damage is usually evident visually on the 850M board. Replacing the obviously damaged board frequently restores operation. However if damage is not evidently visible, swapping boards will determine if the board is at fault.



DC+: ARMATURE CONTROL

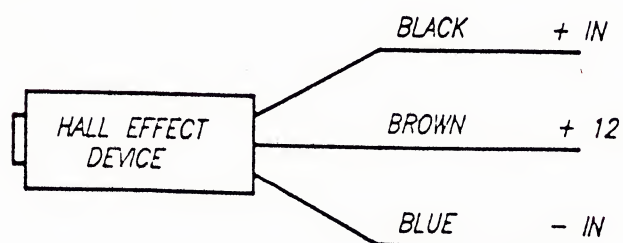
AC1: AC INPUT

AC2: AC INPUT

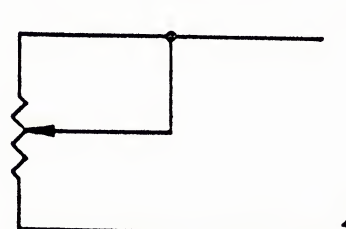
DC-: ARMATURE CONTROL

POTENTIOMER

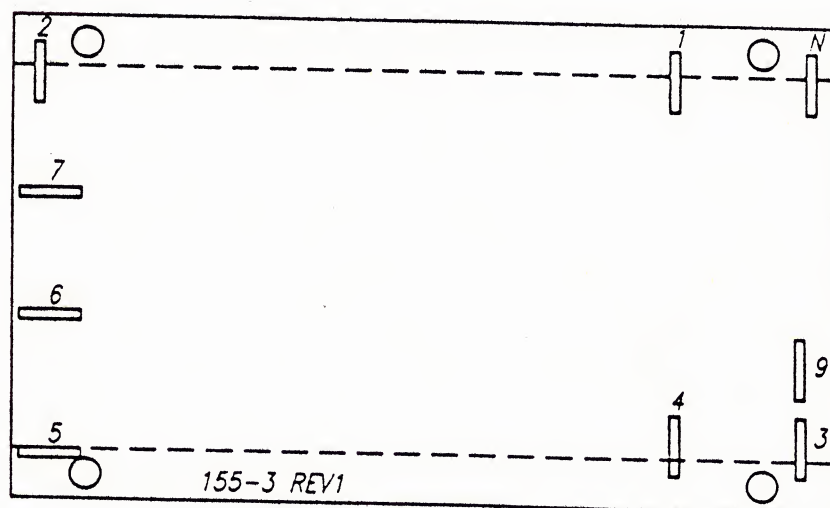
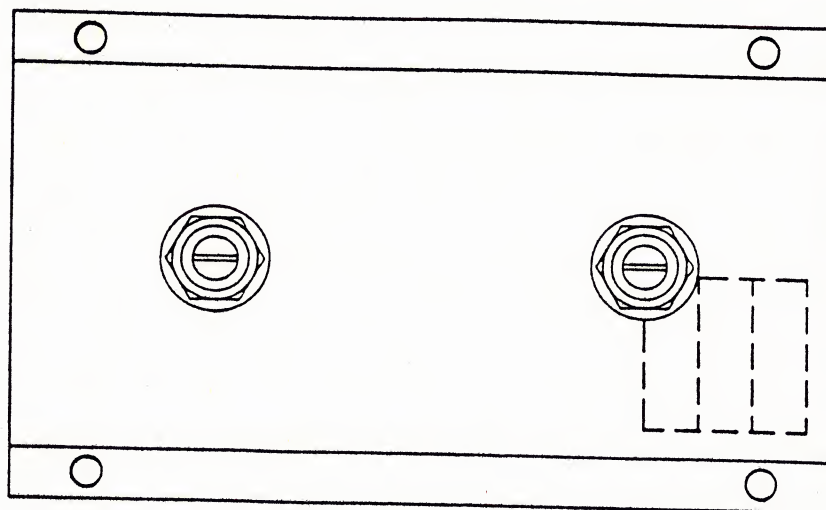
SPAN: HALL EFFECT SENSITIVITY CONTROL



FILM TENSION ADJUSTMENT
REMOTE POTENTIOMETER



336-6
MULTISTRETCH BOARD



- | | |
|---------------|---------------|
| 1: AC INPUT | 7: OUTPUT B/W |
| 2: AC INPUT | 8: N/A |
| 3: COUNT | 9: COMMON |
| 4: RESET | N: NEUTRAL |
| 5: OUTPUT | |
| 6: OUTPUT T/W | |

155-3
COUNTER BOARD